

Date: Thursday, 28/05/2009 11:34:03 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CROSSBOLT SPACER		
Job Number	: 48275			Part Number	: D2743		
Estimate Number	: 10329			Drawing Number	: D2743 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 28/05/2009	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 04/06/2009	Qty:	50
Previous Run	: 45555			Um:	Each		
Written By	:						
Checked & Approved By	: <u>Jul 09.05-28</u>						
Comment	: Est E 05.04.13 Rerformat; removed tumble and deburr step KJ/J LM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0625W065	6061-T6 RD Tube .625 x.065W <i>* 34 remaining</i> <i>17 AF</i>
Comment:	Qty.: 0.2800 f(s)/Unit	Total : 14.0018 f(s)
Material:	6061-T6 (WW-T-700/6) Ø0.625 " x 0.065" wall (M6061T6T0.625W.065) Batch: <u>M1078</u> <i>0706/02</i>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL <i>65</i>
Comment:	1-TURN AS PER FOLIO FA202 & DWG D2743 <i>FOLIO REV: A</i> <i>DWG REV: B</i>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>65</i>
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE <i>65</i>	
4.0	QC8	SECOND CHECK <i>65</i>
Comment:	SECOND CHECK <i>65</i>	
5.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>65</i>
Comment:	PACKAGING RESOURCE #1 <i>Identify and Stock</i> <i>Location: <u>ST Boulby</u></i> <i>09/06/02</i> <i>65</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/06/09 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48275
Description: Cross Bolt Spacer	Part Number:	D2743
Inspection Dwg: D2743	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

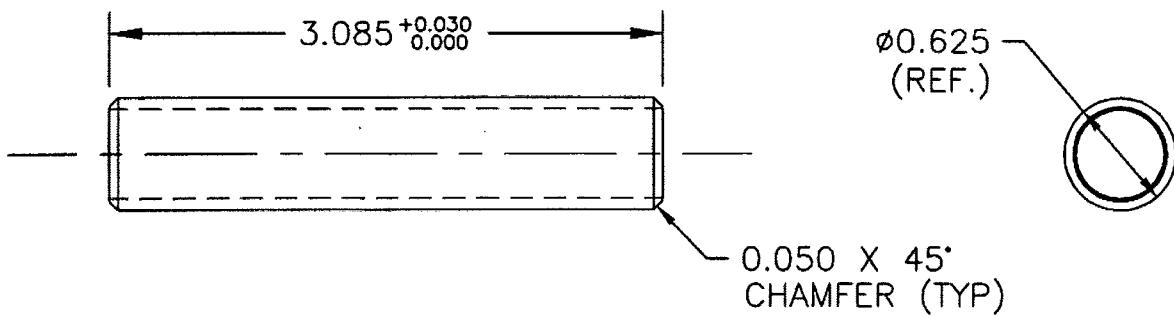
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/06/02	Date:	09/06/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.11.20	Tolerance $+-0.010 \times 45^\circ$ was $0.48 \times 45^\circ$	KJ/JLM	<i>[Signature]</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. REV. B D2743 SHEET 1 OF 1
DATE		TITLE SCALE
98.12.08		CROSS BOLT SPACER 1:1
A	98.04.16	NEW ISSUE
B	98.12.08	3.085 WAS 3.060

RELEASED
98.12.16 DS



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

OPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 118275